

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020727**Date Inspected:** 17-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. ZHU ZHONG HAI**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the side plate to side plate transverse splice weld joint located on 12BE+12CE at cross beam side. The weld is designated as OBE12E-002. The welder is identified as 044515. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-20176.

ZPMC welding personnel performing Air Carbon Arc Gouging & Grinding on UT Repair weld for the edge plate to deck plate hold back weld joint located on 12BE+12CE at cross beam side. The weld is designated as CA3002-006(12BE) & CA3004-002(12CE). ZPMC QC Mr. WANG LI YANG was onsite monitoring the gouging variables. The weld repair report number is named as WR-20200. Further weld detail mention in attached picture.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the I-Rib to edge plate hold back weld joint located on 12BW+12CW at counter weight side. The weld is designated as EP3011-001-011(12CW). The welder is identified as 041713. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

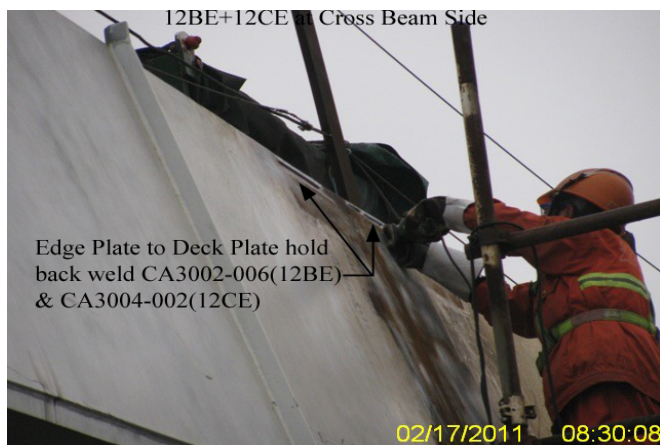
ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the I-Rib to edge plate hold back weld joint located on 12BW+12CW at cross beam side. The weld is designated as EP3008-001-010(12CW). The welder is identified as 057333. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the I-Rib to I-Rib weld joint for side plate located on 12BW+12CW at counter weight side. The weld is designated as SP3053-001-032. The welder is identified as 040611. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the I-Rib to I-Rib weld joint for edge plate located on 12BW+12CW at cross beam side. The weld is designated as EP3008-001-014. The welder is identified as 057333. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) for the bottom plate to bottom plate transverse splice weld joint located on 12BW+12CW. The weld is designated as OBW12C-001.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
----------------------	----------------	-----------------------------

Reviewed By:	Miller,Mark	QA Reviewer
---------------------	-------------	-------------